Work Orde October-02-13		7783		*107	7783*	*****		The state of the s			Page	1
tem ID: Revision ID:	D4020-3		N.	Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Star	IA	S1*	
tem Name:	Mesh (350 Ba	sket Short, Base)							Stop	, <b>*N</b>	S2*	
Start Date:	10/02/13	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	10/16/13	<b>Req'd Qty:</b> 1.00	*1*		Customer:							
Reference:							_	n	Ston			
Approvals:	Process Pla	n:	Date: /3-/0-0	ZTooling:	Da	ate:		K	un Star	171	R1*	
	QC:		Date:		Da	ate:			Stop	` *N	R2*	
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr										
D4020	A											
100				0.00					~		( 24 24 89	
*100*		FLOW WATER JET			0			<u> x</u>	$\mathcal{Q}$		289	
Shear Shear		Memo I-Cut mesh necessary)	at 56.00" (when mesh is or	0.00 n D4017-041 trim mesh t	to finish size if	C 13·10	J. 02					
120	,	QC6- Inspect dimension	ns to drawing	0.00							•	
*120*								0	13-10	2 <u>-02</u>	PD	_
QC		Memo		0.00								
Quality Control			·									
130		Identify as per dwg & St	tock Location: WAU	l / /	6			,			(DA)	١.
*130* Packaging		Memo		0.00	13.10.	02		<u>                                      </u>	9	the same	16.83	
				•								

Packaging

										DQA:	Dat	:e: _	
NCR: Y	es / No				WORK ORDER NON-	100	VFOR	MANCE / UPDATE		OA Classide	Do.		
	<del> </del>					-				QA Closed:	Dat	е.	<del></del>
NA amb Omda	ر ش				DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Work Orde	:I				Rework	1	Skid-tube Crosstube			Water Jet			Engineering
Part N	lo.				Scrap	1	l ,	Machining Small Fat	<b>—</b>	Pro	d. Eng. Coor.	$\dashv$	Quality
					Use-as-is	1		noforming Finishing	<u> </u>	4	e/Packaging		Other
NCR N	lo.				Work Order Update	1		Large Fab Composite	-	1,	Supplier	$\dashv$	
					· ' -			• Ш ,	_				<b></b>
Root				Descri	ption of work order update		Initial	Action		Sign &			
Cause	Date	Step	Qty	•	or Non-conformance	Ch	nief Eng	Description		Date	Verification	1	QC Inspector
Doc/Data						I							
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process				,									
Supplier				•		ı							
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						AUL	T CATE	GORY			···		
Landir	ng Gear				General		Grain			Ovalized	Γ	一,	Pressure/Forced
	Bending			o/s	Bend	$\vdash$	4		-	Over/Under	taloranco	$\dashv$	Fressure/Forced Femperature/Cure
	Centre N	ot Conce	TILTIC TO	U/3	BOM/Route Broken/Damaged	$\vdash$	Hardwa		-	Part Incorred	<b>+</b>	_	Weld
	Cracks	ICrimonad			i i	-	4	ion Incomplete ions Incomplete/Unclear	$\vdash$	Part Lost/Mi	- F		Wrong Stock Pulled
	Crushed/	сттреа		<u> </u>	Burrs Contamination	$\vdash$	-			Part Moved	23111R [	'	WIONG SLOCK Fulled
Cuffs Heat Treat					Countersink	-	<b>⊣</b> ⊢				Vrong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Work Order ID 107783 \*107783\* October-02-13 7:46:05 AM Item ID: D4020-3 Accept \*N900040100\* Setup Start **Revision ID:** Mesh (350 Basket Short, Base) Item Name: Start Oty: 1.00 **Start Date:** 10/02/13 **Cust Item ID:** Required Date: 10/16/13 Req'd Oty: 1.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date:\_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject

**Run Hours** 

0.00

0.00

Work Center ID

\*140\*

Quality Control

140

Description

QC21- Final Inspection - Work Order Release

Memo

1/13/0-x

Code

Qty

Page 2

Insp.

Number Stamp

DQA: Date:

NCR: Y	es	/ No				WORK ORDER NON-	CON	FURIN	HANCE / UPDA		QA Closed:	Dat	:e:			
Nork Örde	r.					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part N	_					Rework Scrap		Skid-tube Crosstube Machining Small Fab			Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Quality		
NCR N	o					Use-as-is Work Order Update				Finishing Composite	Rec/Stor	Supplier		Other		
Root					Descr	iption of work order update	In	itial	Actio	n .	Sign &					
Cause		Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descrip	tion	Date	Verification	1	QC Inspector		
oc/Data		•														
quip/Tooling	$\Box$															
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upplier	_						1									
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		-					FAULT	CATE	ORY							
Landir	ng G	ear			_	General						-				
ļ	ļ	Bending				Bend	Щ	Grain			Ovalized	Ļ	_	ressure/Forced		
		Centre No	t Concer	ntric to (	o/s	BOM/Route	Ш⁺	lardwa	re ·		Over/Under	tolerance	T€	emperature/Cure		
ļ		Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorrec	:t [		/eld		
		Crushed/Crimped Burrs						nstructi	ons Incomplete/Und	clear	Part Lost/Mis	ssing [	\w	rong Stock Pulled		
	Cuffs Contamination						∕Iainte	nance		Part Moved						
	Heat Treat Countersink						\	⁄islabe	led		Positioned W	/rong				
Inspection Strip in Tube Cut Too Short						<u></u>	∕lisread			Power Loss/S	Surge	<u>O</u> 1	ther			
Ripples in Bend Drill Holes							Offset									
		Torque W	aves in E	xtrusion	۱ [	Drawing		Out of C	alibration	-						
		Turning Se	equence			Finish		Out of S	equence	_						
Wave/Twist in Tube Folio Outside Dimensions																

**Picklist Print** October-02-13 7:46:09 AM \*107783\* Work Order ID: 107783 \*D4020-3\* D4020-3 Parent Item: Parent Item Name: Mesh (350 Basket Short, Base) **Start Date:** 10/02/13 Required Date: 10/16/13 Start Qty: 1.00 Required Qty: 1.00 IPP RevA: new issue DD 09.11.26 verified by:EC IPP Rev:B as Comments: per dwg revA 10.03.15 verified by:EC Qty per Kit Total Bin Primary Unit of Qty on Qty Component Item ID/ Replacement Mfg/ Last Route Date Measure Hand Seq ID Issued Item Name Item ID Purch Item Location Location Qty Issued 1,438.273 19.1516 21 M304EX0.75-16F 100 sf Purchased No \*\*

\*M304FX0 75-16F\*

**Expanded Metal Flat SS** 

Lo	ocation	Loc Oty	Loc Code	11/26
W.	A007	1438.273598		
	125457	0.00004402		
	M126052	42.02608		
	M126134	108.417474		
	M126500	73.83		
	M126899	574		
	M127024	640		

Page 1

Status

NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPC	DATE	QA Closed:	Date	<b>:</b> :	
Work Orde	er:					DISPOSITION	OSITION AGAINST DEPARTMENT/PROCESS							
Part N	•					Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Other Supplier			
Root				Γ		ption of work order update	- 1	Initial Action			Sign &			
Cause		Date	Step	Qty		or Non-conformance	Cl	nief Eng	Descri	iption	Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier	Tooling I													
Training Unapproved				1										
опаррточеи	<u> </u>	L	<u> </u>	<u>.                                    </u>			FAUI	LT CATE	GORY		<u> </u>		1	
Landi	ng (	Gear				General								
Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube						Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/U enance eled	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	1	Torque V	aves in l	Extrusio	n I	Drawing	1	Out of Calibration						

Out of Sequence

Outside Dimensions

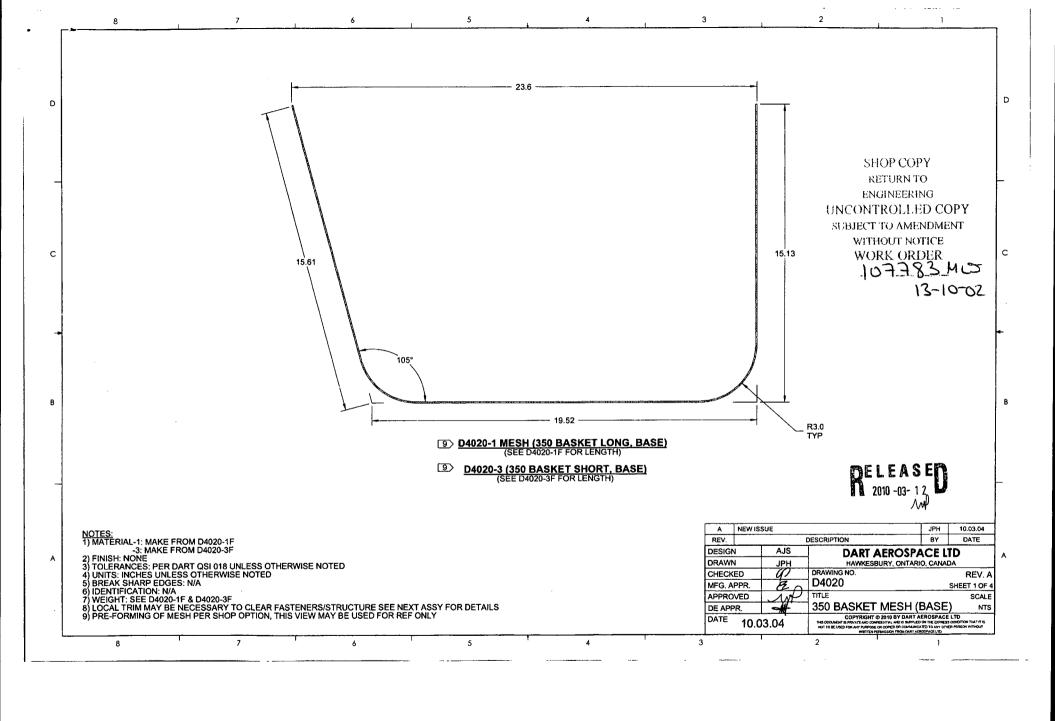
Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish Folio

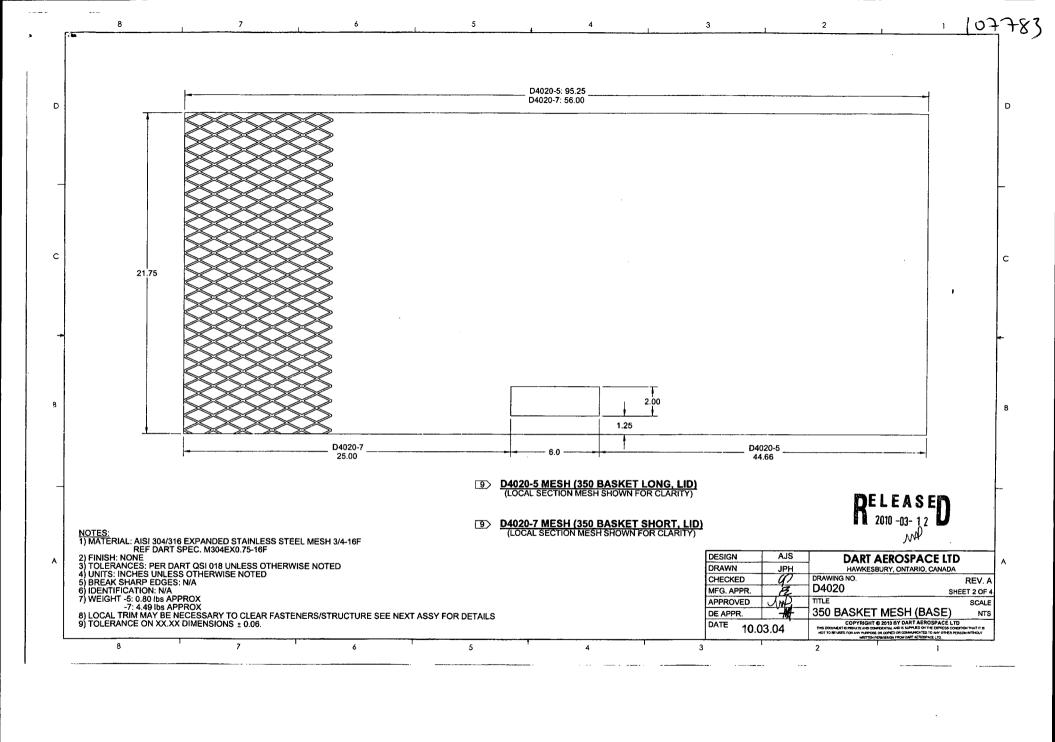


N/CD:	Voc	1	No
NCR:	Yes	/	No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_Date: \_\_\_\_

NCR: Y	es	/ No				WORK ORDER NON-	COM	-UKIN	MANCE / UP	DATE	QA Closed:	Dat	te:		
Work Orde	<u>.</u> .					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	_					Rework Scrap		Skid-tube Crosstube Machining Small Fab				Water Jet d. Eng. Coor.	Quality		
NCR No Work Order Update Large								Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier				
Root					Descri	ription of work order update	Ini	itial	Ac	tion	Sign &				
Cause		Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	n QC Inspector		
oc/Data															
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							FAULT	CATE	GORY						
Landin	ng G	iear			_	General					1	r	<del></del>		
		Bending				Bend	$\vdash$	Grain			Ovalized		Pressure/Forced		
ļ		Centre No	ot Concer	ntric to	o/s	BOM/Route	-	lardwai			Over/Under	tolerance	Temperature/Cure		
Į		Cracks				Broken/Damaged	Ir	rspection	on Incomplete		Part Incorre	ct	Weld		
		Crushed/0	Crimped			Burrs	_		ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
		Cuffs			L	Contamination	∐^	/lainte	nance		Part Moved				
		Heat Trea	it		L	Countersink	Шм	/islabe	led		Positioned V	Vrong			
		Inspection	n Strip in	Tube		Cut Too Short	Cut Too Short Misread Power Loss/Surge								
[		Ripples in	Bend			Drill Holes	Шο	Offset							
		Torque W	aves in E	xtrusio	n [	Drawing		of C	Calibration						
		Turning So	equence			Finish		of S	equence						
Wave/Twist in Tube Folio Outside Dimensions															



												DQA:	Date	2:		
NCR: Y	es	/ No				WOR	K ORDER NON-	100	NFORM	MANCE / UP	PDATE	QA Closed:	Date	::		
Work Orde	ŗ.						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	o					Work Order Update Large Fab Composite				<del>-</del>	Prod. Eng. Coor. Quality  Rec/Store/Packaging Other					
Root		Date	<b>C</b> 4 - ·	0.1	Descr	-	work order update	1	nitial ief Eng		ction cription	Sign & Date	Verification	QC Inspector		
Cause loc/Data quip/Tooling perator Material etup other rocess upplier raining				Step Qty or Non-conformance												
							F	AUL	T CATE	GORY						
Landir	Landing Gear  Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion						General  Oute  /Damaged  nation  rsink  Short  les	$\vdash$	Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete, nance led	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
		Turning S			''	Drawing Finish	5	-	4	Seguence						

Outside Dimensions

Wave/Twist in Tube

Folio

107783 17.31 8 0.40 8 15.50 2.00 0.38 5.64 75° R3.38 2 PL 8 20.18 9 D4020-11 END MESH, BASKET 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F DESIGN AJS 2) FINISH: NONE DART AEROSPACE LTD 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 1.22 Ibs
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06. DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR SHEET 3 OF 4 TITLE APPROVED SCALE 350 BASKET MESH (BASE) NT

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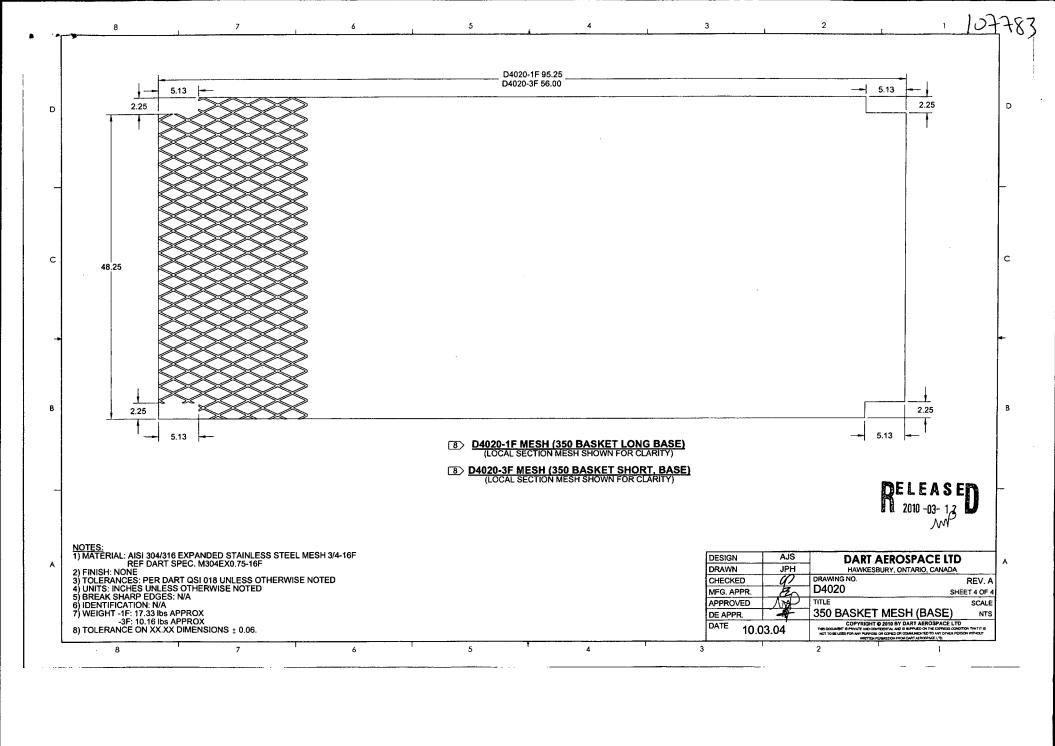
THE DOUGLEH'S FRINKT MA DOWNEDING, MAD BURNED OWNED COMPAND THAT IT AS

ON'T DE (SUSDIAM ME PROPOSE ORDERO OR COMMAND TO MAY THAT PRISON HITHOUT DE APPR NTS DATE 10.03.04

NCR:	Yes	1	No
		,	

DQA: \_\_\_\_\_Date: \_\_\_\_\_

NCR: Y	es	/ No				WORK ORDER NON-	COI	VFORI	MANCE / UP	DATE		QA Closed:	Da	te:	
Nork Orde	ŗ.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	•					Rework Scrap		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing				Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality
NCR N	ο.					Use-as-is Work Order Update		Thermoforming Finish  Large Fab Compos				Rec/Sto	re/Packaging Supplier	$\overline{}$	Other
Root					Descri	ription of work order update	T	Initial Action Sign &							
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
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		Bending			Ĺ	Bend	$\vdash$	Grain		1		Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route	$\vdash$	Hardwa		<u> </u>	-	Over/Under		$\sqcup$	Temperature/Cure
		Cracks				Broken/Damaged		4	on Incomplete	Ļ		Part Incorre		$\vdash$	Weld
		Crushed/0	Crimped		_	Burrs		-1	ions Incomplete/	Unclear		Part Lost/M	issing		Wrong Stock Pulled
		Cuffs				Contamination	<u> </u>	Mainte		Ļ	_	Part Moved			
		Heat Trea	it			Countersink		Mislabe	led	Ļ	_	Positioned \	_		1
		Inspection	n Strip in	Tube	<u></u>	Cut Too Short		Misread	I	Ĺ		Power Loss/	Surge		Other
i		Ripples in	Bend		_	Drill Holes		Offset							
		Torque W	/aves in E	xtrusio	n L	Drawing		Out of C	Calibration						
		Turning S	equence			Finish	L	Out of S	Sequence						
	Wave/Twist in Tube Folio Outside Dimensions														



NCR: Y	es / No				WORK ORDER NON-O	CON	FORM	MANCE / UPDATE					
•										QA Closed:	Date:		
Work Orde	er:				DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS		
Part N				· · · · · · · · · · · · · · · · · · ·	Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Water Jet Engineering Prod. Eng. Coor. Quality Rec/Store/Packaging Supplier			
Root				Descri	ption of work order update	lr	nitial	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Description		Date	Verification	QC Inspector	
Doc/Data Equip/Tooling Operator Material Setup Other Process										,			
Supplier Training Unapproved				·	. •	:  -  -  -  -							
					F	AUL1	CATE	GORY					
Landi	ng Gear				General					-		=	
à	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio Ripples ir	Crimped at n Strip in n Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/Unclear enance eled		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	st ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	
	Turning S	Sequence	:		Finish		Out of 9	Sequence					

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio